

Order ID 79084 -1

12 1:42:16 PM

SPLIT 2

79084

Page 1

Item ID:

D3560-042

Revision ID:

Item Name:

Arm Weldment

Start Date:

19/01/2012

Required Date:

02/02/2012

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLJ

Date: 12/01/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

Rev D

D3560

BAND SAW

0.00

Memo

Cut blanks 16.750" diam

0.00

M.A 12/01/28

10 0

110

1110

HAAS

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

1- Mill as per Folio FA694 Rev: 4A & Dwg D3560 Rev: 0
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

0.00

10 0

12/01/3

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10 0

12/01

Work Order ID 79084

January-19-12 1:42:16 PM

79084

Page 2

Item ID: D3560-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Arm Weldment

Stop *NS2*

Start Date: 19/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

2/12/01/31

10

10

140

140

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560
STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

Alum. Rod # 119712

1/12/02/01

3

3

Work Order ID 79084

January-19-12 1:42:16 PM

79084

Page 3

Item ID: D3560-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

8/2/02/01

(+3)
042

3 0 12-02-01

12-02-01

3 0

Work Order ID 79084

January-19-12 1:42:16 PM

79084

Page 4

Item ID: D3560-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

180

QC

Quality Control

QC5- Inspect Part Finish
6 OCT

Memo

0.00

0.00

3 HR 12-2-1

190

190

Small Fab

Small Fab

Small Fab

Memo

1-Press bushing in D3560 arm per dwg D3562

0.00

0.00

EP 12/02/01 (3)

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/12/01

(73)

-042

Work Order ID 79084

January-19-12 1:42:16 PM

79084

Page 5

Item ID: D3560-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Arm Weldment

Stop *NS2*

Start Date: 19/01/2012 Start Qty: 6.00

6

Required Date: 02/02/2012 Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

Identify as per dwg & Stock Location: *NA*

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL ***

12.02.01

3

Ø

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/2/11

pl 12-02-1

Picklist Print

January-19-12 1:42:20 PM

Page 1

Work Order ID: 79084

79084

Parent Item: D3560-042

D3560-042

Parent Item Name: Arm Weldment

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

22.0000

1

6

D2808

Bushing

**

Location

Loc Qty

Loc Code

GA

22

32896

2

71879

8

76188

12

M6061T6B0.500X05.00
0

Purchased

No

140

f

59.7480

1.395

8.810526

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

35.748

112154

6.935

117933

4.813

119324

24

MAT004

24

120243

24

→ 120421

14.0000^{ft}

12/02/01

12/01/28

Picklist Print

January-19-12 1:42:20 PM

Page 2

Work Order ID: 79084

Parent Item: D3560-042

Parent Item Name: Arm Weldment

79084

D3560-042

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured No

190

Each

15.0060

1

6

**

12.02.01

D3592-1

Plate

Location

Loc Qty

Loc Code

WA

6

78934

6

WA002

9

47015

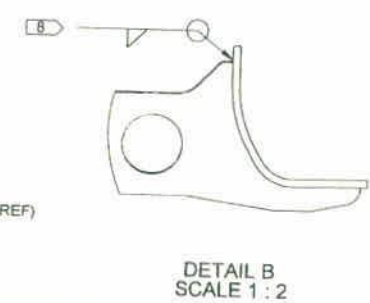
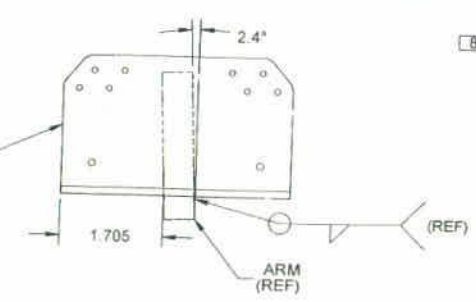
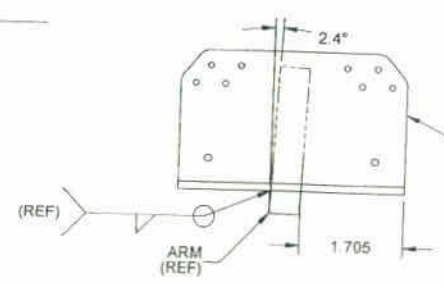
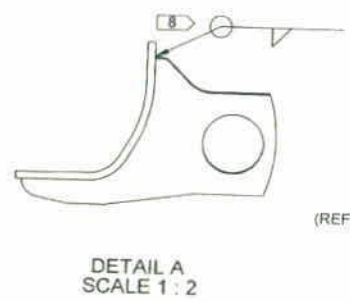
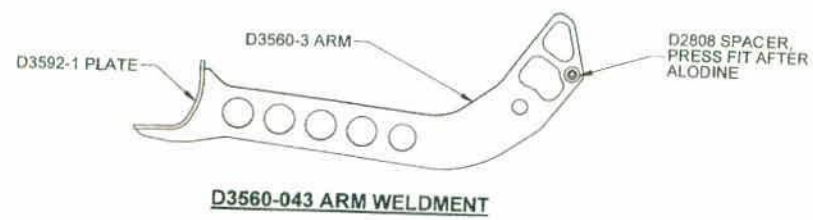
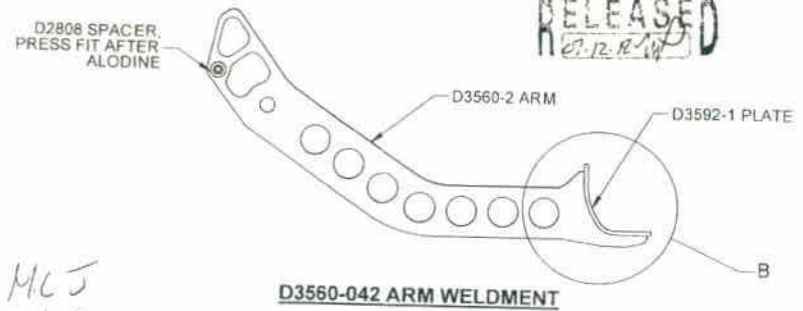
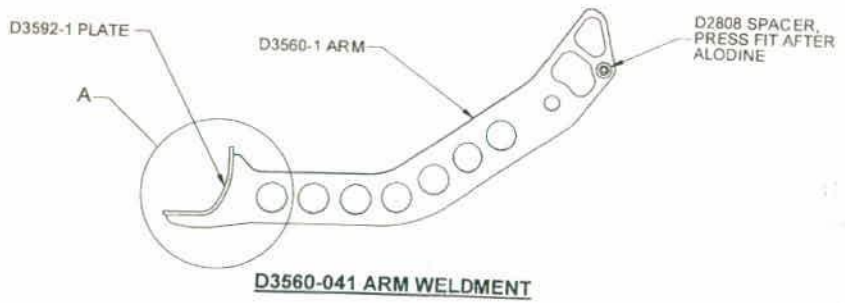
2

48517

7

1
2

RELEASED
07.12.16



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1	1	1	1	D3560-1	ARM
	1	1	1	D3560-2	ARM
		1	1	D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

DESIGN	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.05.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560**

TITLE **ARM WELDMENT**

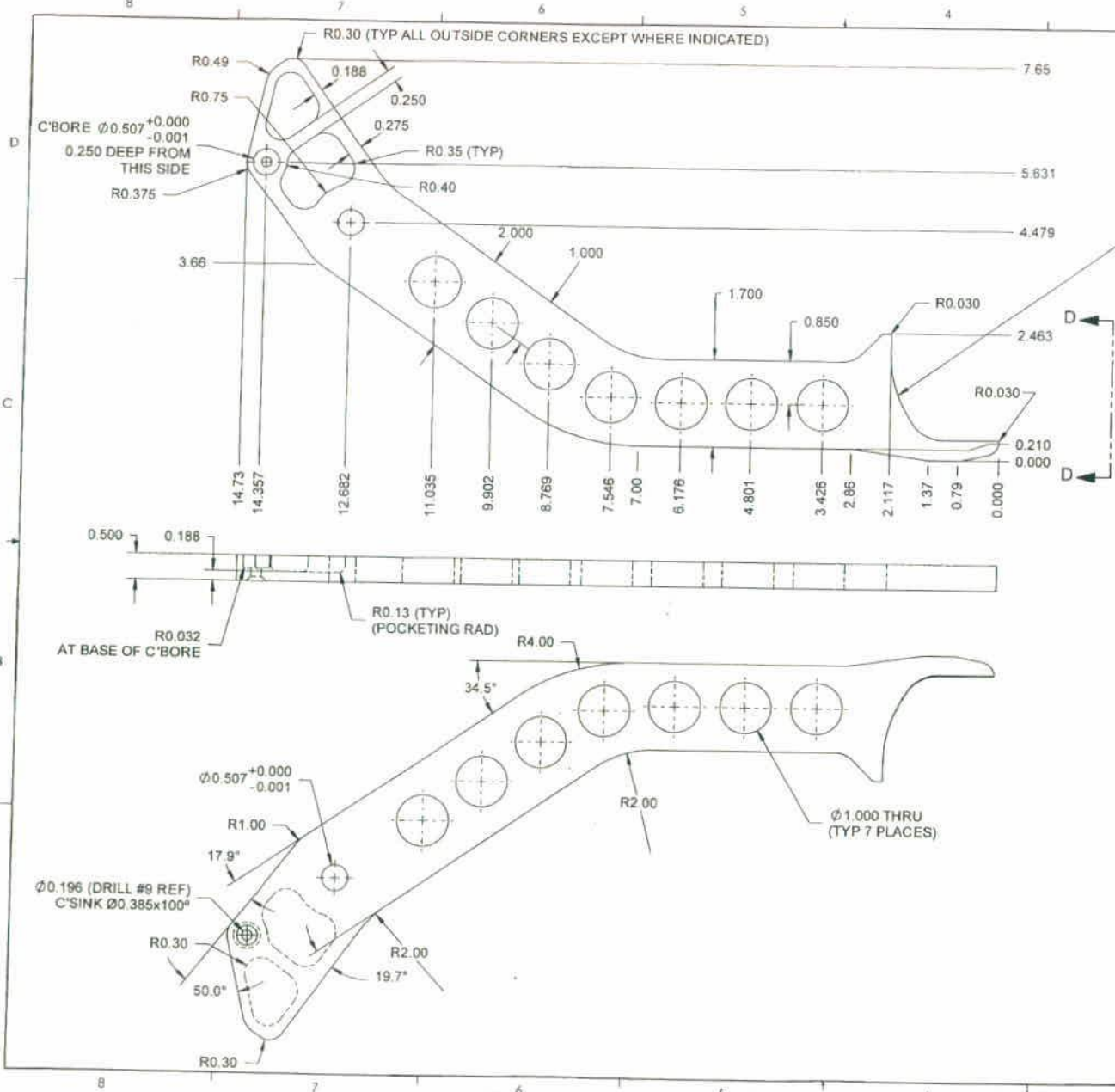
REV. D

SHEET 1 OF 5

SCALE 1:4

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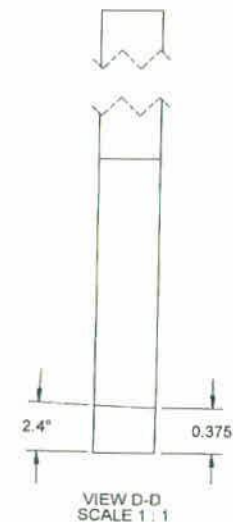
79084



PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4",
SEE VIEW D-D

D3560-2 ARM

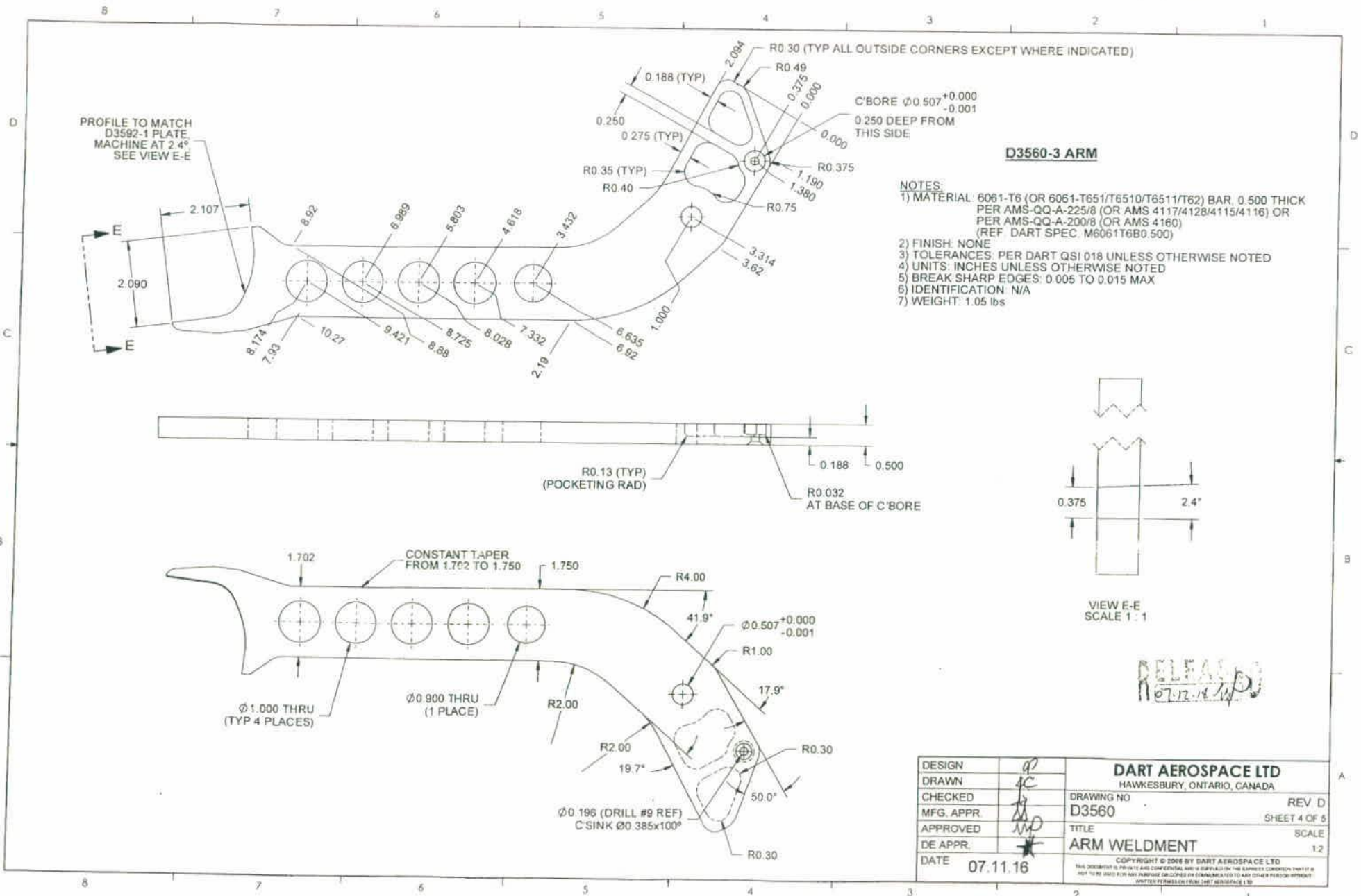
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF: DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW D-D
SCALE 1:1

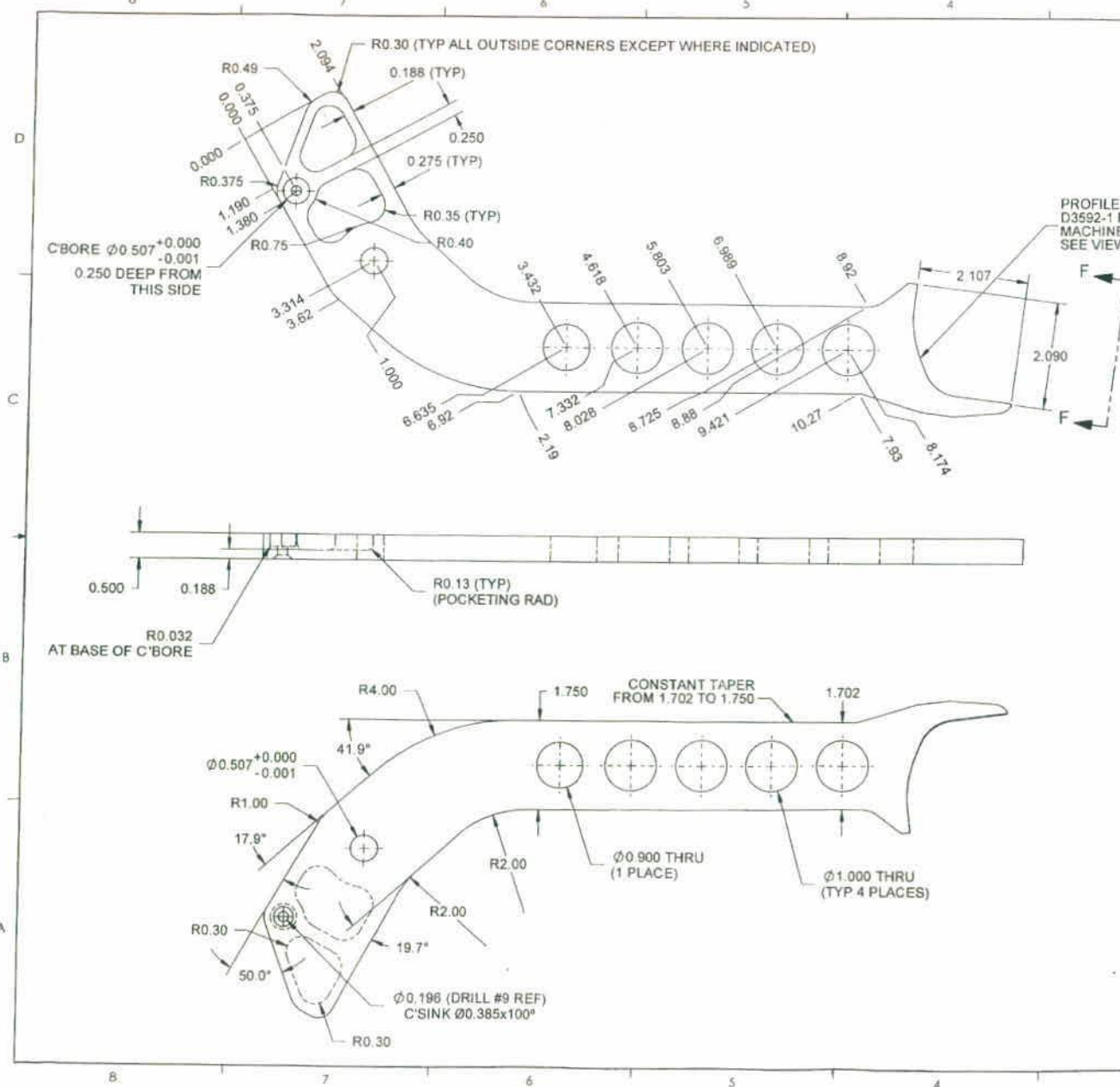
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DRAWN	g		
CHECKED	g	DRAWING NO. D3560	REV. D
MFG. APPR.	g	SHEET 3 OF 5	
APPROVED	g	TITLE ARM WELDMENT	SCALE 1:2
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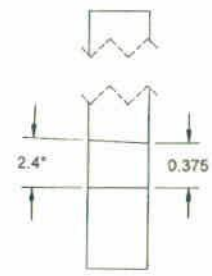
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DRAWN	AC		
CHECKED	AC	DRAWING NO.	REV. D
MFG. APPR.	AC	D3560	SHEET 4 OF 5
APPROVED	AC	TITLE	SCALE
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79084



D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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